



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

SWA3-200

Job Sheet 183080



Part No: SWA3-200

Job Qty: 10 ea

Part Name: Lower End



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/12/18

Job Tracking No:

Due Date: 10/12/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG SWA3-200 Rev 12 IPP Rev A 18.02.13 New issue DP verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	10/12/18	10/12/18	0.00	0.00	Start Up Machining-3		
110	Mori Seiki	10 pcs	10/12/18	10/12/18	0.00	10.00	MORI NLX		
120	QC	10 pcs	10/12/18	10/12/18	0.00	0.00	QC2		
130	QC	10 pcs	10/12/18	10/12/18	0.00	0.00	QC8		
140	Packaging	10 pcs	10/12/18	10/12/18	0.00	0.00	Packaging3		
150	QC21-SA	10 Ea	10/12/18	10/12/18	0.00	0.00	QC21		

Part Op Descriptions: 110 - 1-Machine as per DWG.FC301 FOLIO REV: AA DWG REV: 12 2-Debur

NOV 26 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H1150-R1.500	17-4 SS Round Bar 1.500"	3.6000 ft (.36 ea)	90-Start up Operation	312 383

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-H1150-R1.500	4	1	0

Part Specifications

Specifications could not be found.

Plex 9/12/18 10:05 AM Dart.lajeunesse.marie



Container No: S127391



Part: SWA3-200

Job No: 183080

Serial No/Batch: S127391

Revision: 12

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/13/18

DART AEROSPACE LTD		Work Order:	SW 183080
Description: Lower END		Part Number:	SW A3-200
Inspection Dwg: SWA3-200		Rev: 12	Page 1 of 1

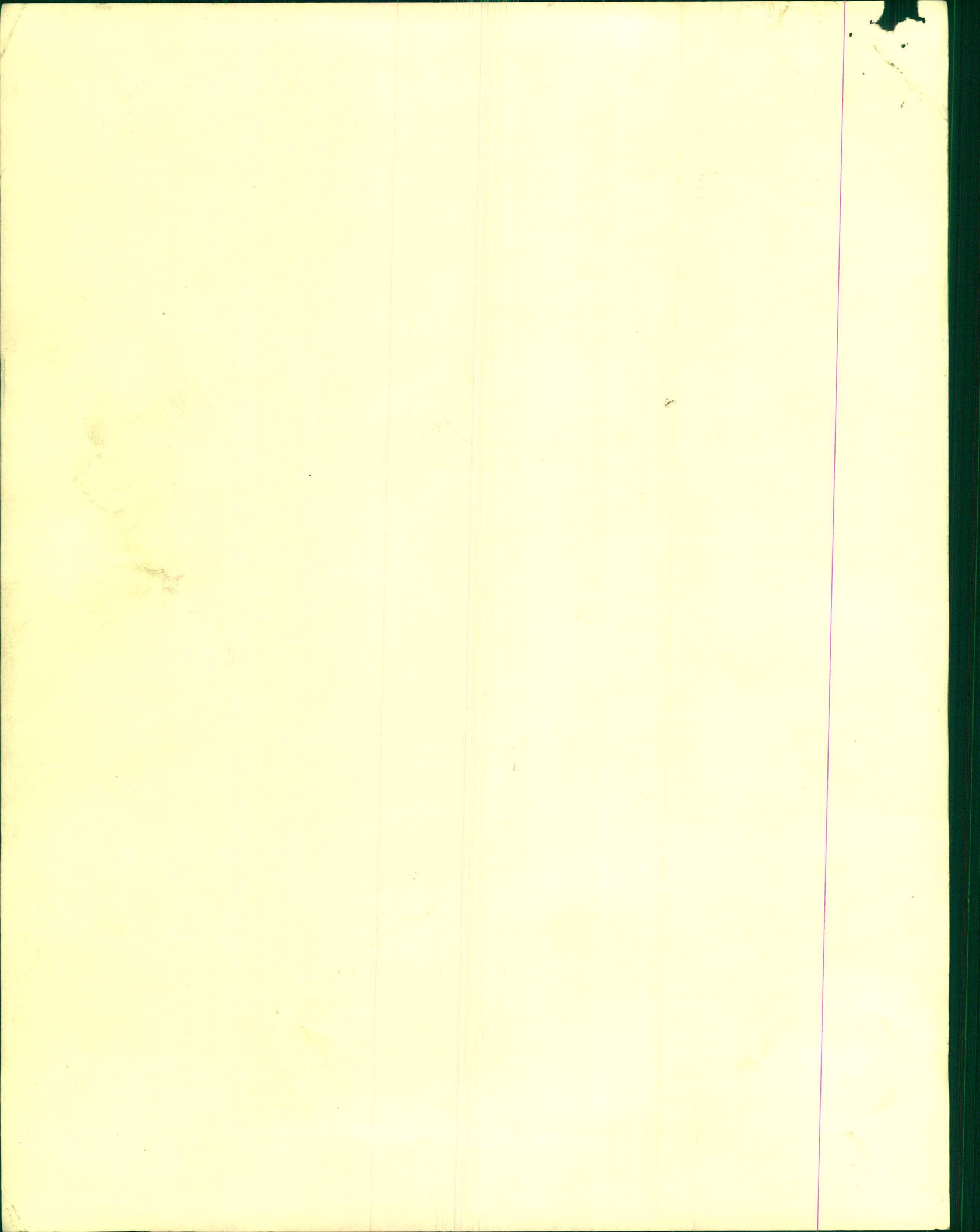
INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.20	$\pm .01$	4.195	✓		Vern LPID	
.38	$\pm .01$	.38				
45°	$\pm .5^\circ$	45°				
1.95	$\pm .01$	1.960				
Ø .750	$+ .01 / - .00$	.756				
Ø 1.066	$+ .000 / - .003$	1.065				
.03 x 45°	$\pm .01 \times .5^\circ$	.035 x 45°				
Ø .75	$\pm .01$	.750				
R .07	$\pm .01$	.062			Rad gauge	
Ø .640	$+ .01 / - .00$	.645			Vern LPID	
.81	$\pm .010$	.808				
R .188	$\pm .005$	.1875			Rad gauge	
.27	$\pm .01$	.268			Vern LPID	
Ø 1.50	$\pm .01$	1.495				
.02 x 45°	$\pm .01 \times .5^\circ$	.022 x 45°				
.75	$+ .00 / - .02$	.740				
1.75	$\pm .01$	1.750				
Ø .438	$\pm .005$	.440				
.720	$\pm .005$	.723				
1.396	$+ .005 / - .000$	1.398				
Ø 1.305	$+ .000 / - .005$	1.3025				
8-32 UNC-2B	G-D / NO G-D	G-D			GO-NOGO	
.125	$\pm .005$	.125			Vern LPID	
1.73	$\pm .01$	1.720				
2.06	$\pm .01$	2.053				
.03 x 45°	$\pm .01 \times .5^\circ$	.035 x 45°				
10-32 UNF-2B	G-D / NO G-D	G-D			GO-NOGO	
.50	$\pm .00$	.50			Vern LPID	

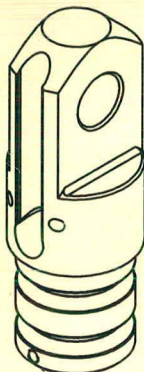
Measured by:	<i>[Signature]</i>	Checked by:	<i>[Signature]</i>	QC Inspector:	
Date:	18-11-14	Date:	18/11/24	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	



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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
7		AS DRAWN BY CANAM	8/24/2012	
8		ADDED MISSING .750 DIM, ADDED DEPTH .500 TO Ø.750	11/14/2012	JAG
9		DELETED .02 X 45° FROM TOP, ADDED DRILL POINT DETAIL AND (1.99) DIM.	8/6/2013	RJC
10	16-0084	REMOVED DIMS .981, .976, .381, .376. ADDED DIMS .420±.002, .425±.002, 1.020±.002, 1.025±.002. CH'D DIM WAS 1.75 IS 2X 1.75, WAS Ø1.066+0.00/-0.03 IS 2X Ø1.066+0.00/-0.03, WAS .750 IS .75+0.0/-0.02. CH'D MATERIAL, WAS S.S. 17-4 PH, IS S.S. 17-4 H1150/H1075.	7/18/2016	SM
11	17-0027	CH'D DIM'S WAS .375 IS .38, WAS Ø.750 +0.01/-0.00 Ø.500 IS Ø.750 +0.01/-0.00 Ø.1.95, WAS R.069 IS R.07, WAS 2X .030 X 45° IS 2X .03 X 45°, WAS 2X 10-32 UNF -2B Ø.500 IS 2X 10-32 UNF -2B Ø.50, WAS 8-32 UNC -2B Ø.328 IS 8-32 UNC -2B Ø.33, WAS 4X R.015 IS 4X R.02. DELETED DIM'S 1.95, Ø.750. ADDED NOTE MACHINE ENGRAVE BATCH #.	2/1/2017	RJC
12	17-0146	CH'D DIM WAS Ø.750 +0.01/-0.00 Ø.1.95 IS Ø.750 +0.01/-0.00 Ø.50. DELETED DIM (1.99). ADDED DIM'S 1.95, Ø.75.	6/20/2017	RJC

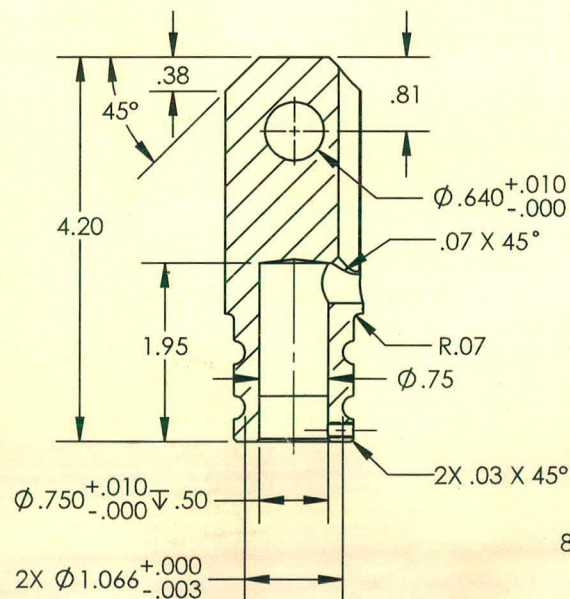
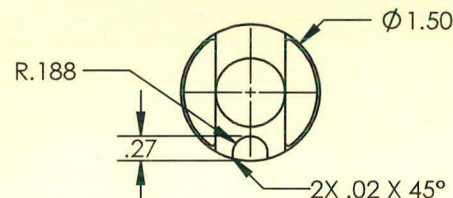
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RETURN TO
ENGINEERING

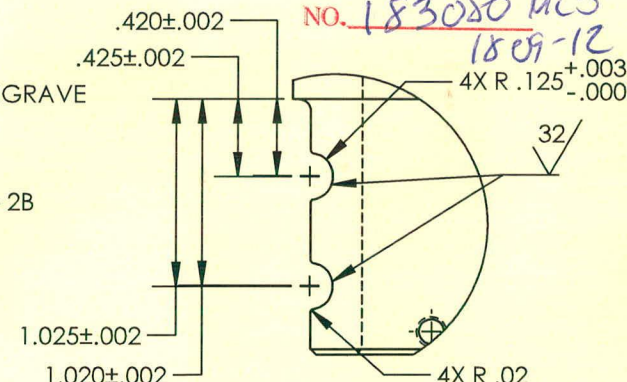
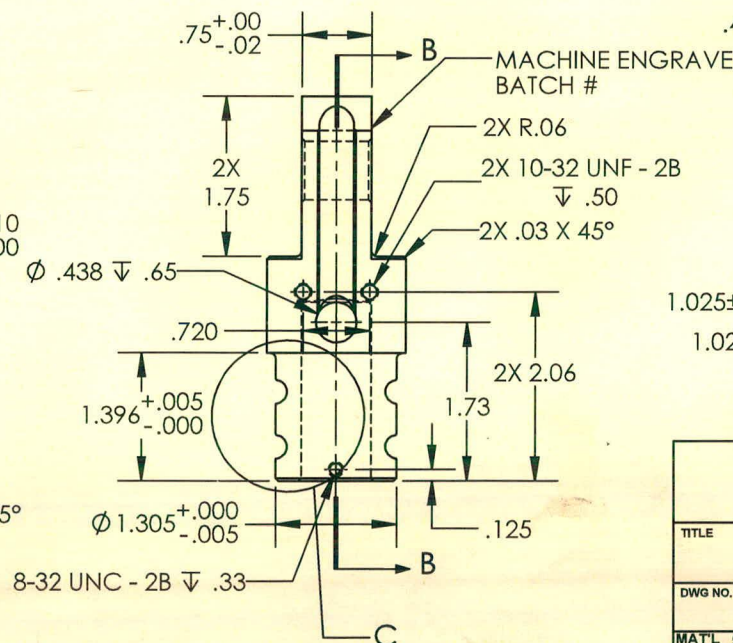
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 183080 MLC
1809-12



SECTION B-B



DETAIL C
SCALE 1 : 1

DART AEROSPACE	
TITLE LOWER END	
DWG NO. SWA3-200	REV 12
MAT'L S.S. 17-4, H1150/H1075 HEAT TREAT FINISH SPEC DRAWN BY: CANAM CHECKED: CLOUGH OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓ 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL	
SCALE 1:2	DATE 5/16/2006
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			SWA3-200	1	LOWER END	S.S. 17-4, H1150/H1075		

